

Work Order ID 79085

79085

Page 1

January-19-12 1:42:56 PM

Item ID: D412-630-033

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli Access Step LH Folding

Start Date: 19/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.C.J Date: 12/01/19 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

8 12/02/29

~~M.C.J 12/02/19~~

110 0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M119317

COAT exposed HARDWARE WITH LPS PROCYON

A/R LPS PROCYON BATCH: M114596

12/02/29 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S r12/29			(4) WH			
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00				SP 12-02-23.			
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	S r12/29			(4) WH			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:

Item Name: Heli Access Step LH Folding

Stop ***NS2***

Start Date: 19/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

4

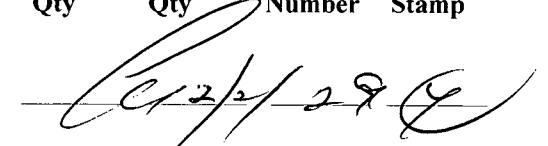
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-033								
	Location: <u>SHIP</u>								
	PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									



MLJ 12/02/29

MF
12-02-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 1

Work Order ID: 79085

79085

Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn 1019, added d2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-107 *D2012-107* Clevis		Manufactured	No			110	Each	41.0000	1	4	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST004		41							
				71602		3							
				75057		38							
D2803-041 *D2803-041* Bracket Assembly		Manufactured	No			110	Each	5.0000	1	4	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST147		5							
				74804		1							
				77931		4							
D2804-041 *D2804-041* Bracket Assembly		Manufactured	No			110	Each	4.0000	1	4	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST150		4							
				76182		4							

SP

4/12/02/28
B 79166 (4x)

4/12/02/28
B 79299 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2807-041

Manufactured No

110

Each

35.0000

2 8

D2807-041

Door prop

**

B79007 sp FA

Location

Loc Qty

Loc Code

ST018

35

60540

2

68494

5

73030

10

73920

2

77152

16

D2813

Manufactured No

110

Each

17.0000

2 8

D2813

Washer

**

B79691 sp
8x

Location

Loc Qty

Loc Code

ST018

17

69386

1

75025

16

D3562-041

Manufactured No

110

Each

0.0000

1 4

D3562-041

Step Assembly, LH

D3395-1

Manufactured No

110

Each

33.0000

4 16

D3395-1

Bushing

**

~~B79007~~

B78840 SP

12-02-23

Location

Loc Qty

Loc Code

ST041

33

71563

33

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

79085

D412-630-033

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN3C21A

Purchased

No

AN3C21A

BOLT

110

Each

86.0000

2

8

**

SP

Location

Loc Qty

Loc Code

ST352

86

109148

2

117514

34

119798

50

5x

AN8C16

Purchased

No

AN8C16

Bolt

110

Each

26.0000

2

8

**

SP m/20578 4x.

Location

Loc Qty

Loc Code

ST343

26

106066

2

118451

15

119324

9

4x

AN310C8

Purchased

No

AN310C8

Nut

110

Each

42.0000

2

8

**

SP

Location

Loc Qty

Loc Code

ST344

42

118378

12

119324

10

120308

20

2x

6x.

MS24665-302

Purchased

No

MS24665-302

Cotter Pin

110

Each

77.0000

6

24

**

SP 12-02-23

Location

Loc Qty

Loc Code

ST309

77

117460

77

24x

January-19-12 1:43:00 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 4

Work Order ID: 79085

79085

Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3

Purchased

No

110

Each

151.0000

4

16

NAS1515H3

Washer

**

SP

Location

Loc Qty

Loc Code

ST277

151

116373

6

118078

6

118384

11

119438

28

120142

100

SP
M120518
@

NAS1515H5L

Purchased

No

110

Each

170.0000

4

16

***NAS1515H5I ***

WASHER

**

SP

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

130

119902

130

10-10x

NAS1515H8

Purchased

No

110

Each

139.0000

4

16

NAS1515H8

Washer

**

SP 12-02-23.

Location

Loc Qty

Loc Code

ST277

139

111275

4

111411

135

10x

10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 5

Work Order ID: 79085

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

79085

D412-630-033

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

110

Each

1,243.000

4

16

MS21043-3

Nut

**

SP

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

632

119901

632

ST301

539

118077

2

118614

441

118686

30

119758

66

100x

MS24693-C280

Purchased

No

110

Each

48.0000

2

8

MS24693-C280

Screw

**

SP 12-02-23

Location

Loc Qty

Loc Code

ST310

48

118612

48

130

Each

14.0000

2

8

D2806-1

Manufactured

No

D2806-1

Bushing

**

8x

B78888

SP 12-02-24

Location

Loc Qty

Loc Code

ST018

14

75047

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 79085

79085

Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D2806-3

Manufactured No

130

Each

27.0000

2 8

D2806-3

Bushing

**

Location

Loc Qty

Loc Code

ST018

27

75046

15

76187

12

130

Each

7.0000

1 4

D2810-5

Manufactured No

D2810-5

Strut

**

Location

Loc Qty

Loc Code

ST265

7

52034

1

75077

6

130

Each

12.0000

2 8

D3396-1

Manufactured No

D3396-1

Spacer

**

Location

Loc Qty

Loc Code

ST041

12

75049

12

130

Each

364.0000

1 4

AN4C6A

Purchased No

AN4C6A

Bolt

**

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

360

116704

8

119328

152

119749

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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January-19-12 1:43:01 PM

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Work Order ID: 79085

Parent Item: D412-630-033

Parent Item Name: Heli Access Step LH Folding

79085

D412-630-033

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C10A

Purchased

No

130

Each

50.0000

1

4

S ***AN4C10A***

Bolt

**

SP

L

Location

Loc Qty

Loc Code

ST356

50

112243

20

114523

30

4x

AN5C15A

Purchased

No

130

Each

61.0000

2

8

S ***AN5C15A***

Bolt

**

SP

L

Location

Loc Qty

Loc Code

ST338

61

118191

3

118267

33

119749

25

8x

AN44C7A

Purchased

No

130

Each

42.0000

1

4

S ***AN44C7A***

Eyebolt

**

SP

L

Location

Loc Qty

Loc Code

ST362

42

109013

2

111308

40

4x

AN4C15A

Purchased

No

130

Each

109.0000

2

8

S ***AN4C15A***

Bolt

**

SP 12-02-24

L

Location

Loc Qty

Loc Code

ST358

109

115835

2

118628

7

118706

100

8x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 79085

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Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4

Purchased

No

130

Each

151.0000

7 28

NAS1515H4

Washer

**

M/20498 SP ✓

Location

Loc Qty

Loc Code

ST277

151

116169

3

117460

1

117735

3

118078

48

118612

46

120120

50

NAS1515H5

Purchased

No

130

Each

280.0000

7 28

NAS1515H5

Washer

**

SP 12-02-23 ✓

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

240

103286

65

120299

75

120304

100

28x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-630-033

D412-630-033

Parent Item Name: Heli Access Step LH Folding

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

130

Each

2,035.000

4

16

MS21043-4

**

SP

h

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

1525

119309

29

119546

496

120308

1000

16x

MS21043-5

Purchased

No

130

Each

581.0000

3

12

MS21043-5

**

SP 12-02-23

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST300

136

112314

136

ST301

425

116548

100

118159

100

119307

25

119537

200

12x

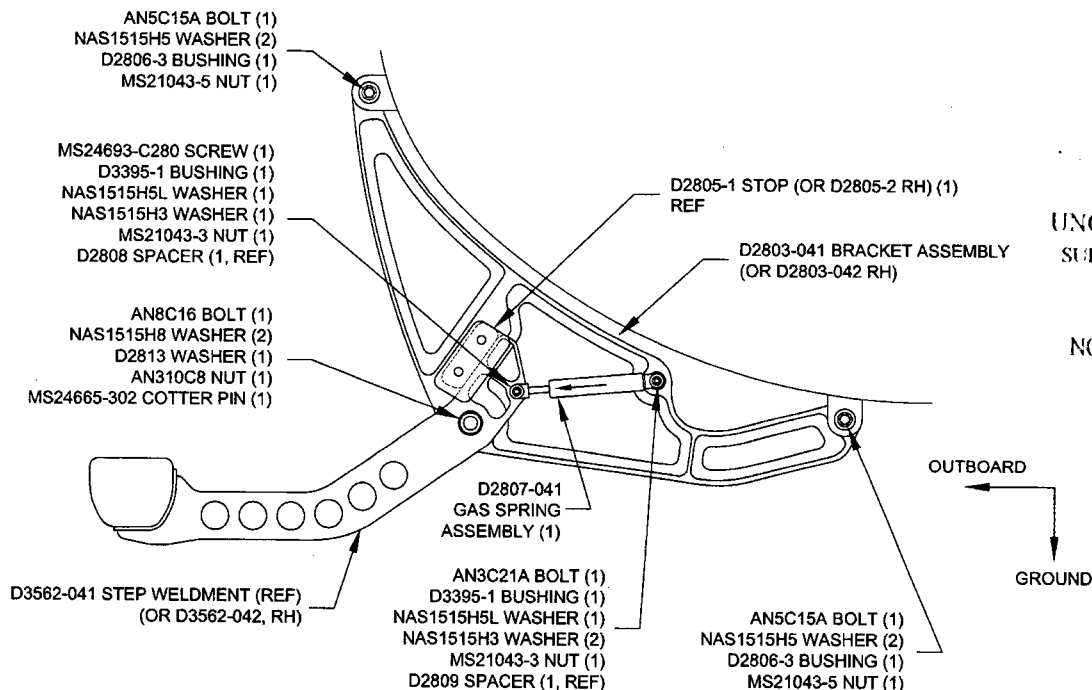
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

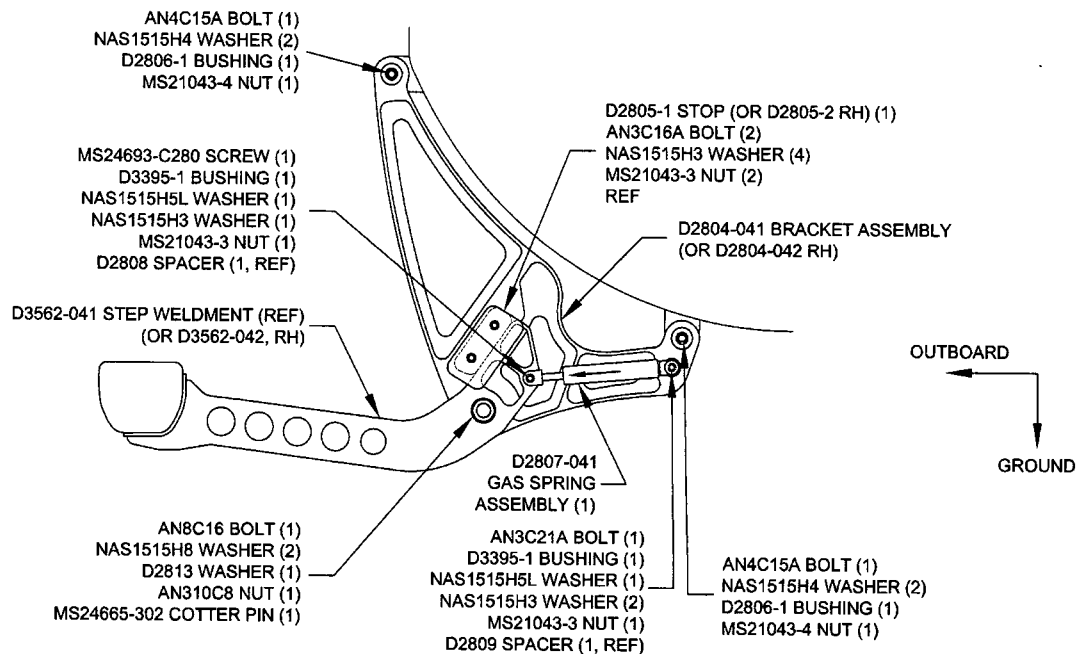
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation

SHOP COPY
 REFER TO
 FOR INSTRUCTIONS
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 35005

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
 (View rotated 90° CW)**



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
 (View rotated 90° CW)**

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Revision: **M**
 Date: 08.12.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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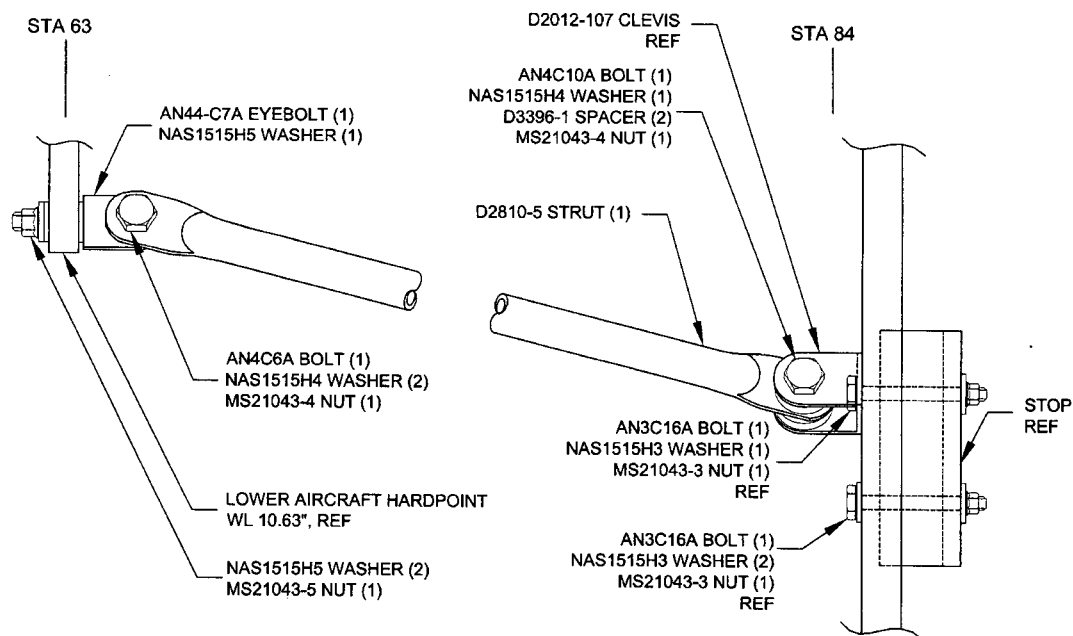


FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step*™ Installation
(NOT TO SCALE)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

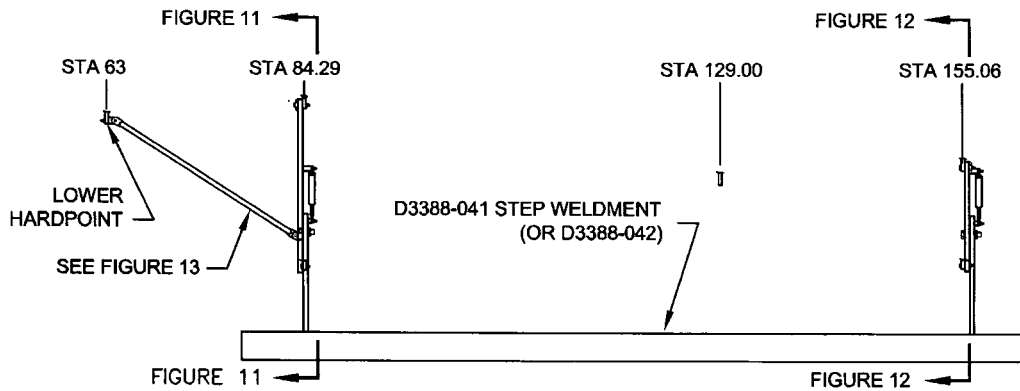
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

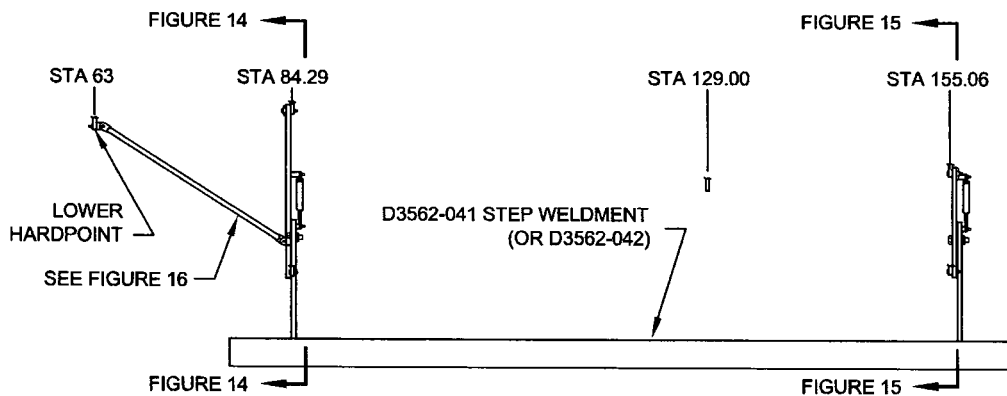
• **NOTE:** Date & initial all entries

• H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

D412-630-023 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-024 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-033 HELI-ACCESS-STEP™ LH, FOLDING (SHOWN)
D412-630-034 HELI-ACCESS-STEP™ RH, FOLDING (OPPOSITE)



D412-630-111 HELI-ACCESS-STEP™ LH, HEAVY DUTY FIXED (SHOWN)
D412-630-112 HELI-ACCESS-STEP™ RH, HEAVY DUTY FIXED (OPPOSITE)

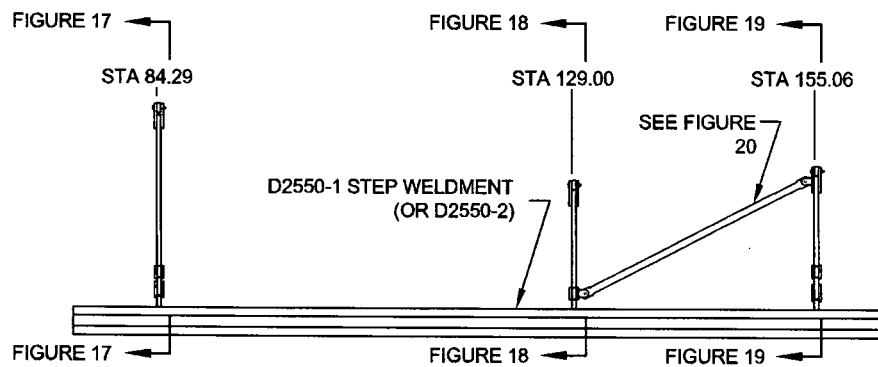


FIGURE 3 – D412-630 Heli-Access-Step™ Installations

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Revision: **M**
 Date: 08.12.12

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
		2	2	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		6	6	NAS1515H3	WASHER
7	7			NAS1515H4	WASHER
7	7			NAS1515H5	WASHER
		4	4	NAS1515H5L	WASHER
		4	4	NAS1515H8	WASHER
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C565)